Section 1. Registration Information

Source Identification

Facility Name:	SEMCO SOUTH COOLING
Parent Company #1 Name:	HILLTOWN PACKING, INC.
Parent Company #2 Name:	

Submission and Acceptance

Submission Type:	Re-submission
Subsequent RMP Submission Reason:	5-year update (40 CFR 68.190(b)(1))
Description:	
Receipt Date:	05-Aug-2010
Postmark Date:	05-Aug-2010
Next Due Date:	05-Aug-2015
Completeness Check Date:	05-Aug-2010
Complete RMP:	Yes
De-Registration / Closed Reason:	
De-Registration / Closed Reason Other Text:	
De-Registered / Closed Date:	
De-Registered / Closed Effective Date:	
Certification Received:	Yes

Facility Identification

EPA Facility Identifier:	1000 0018 7683
Other EPA Systems Facility ID:	

Dun and Bradstreet Numbers (DUNS)

Facility DUNS:	
Parent Company #1 DUNS:	
Parent Company #2 DUNS:	

Facility Location Address

Street 1:	3820 E 36th Street
Street 2:	
City:	Yuma
State:	ARIZONA
ZIP:	85365
ZIP4:	
County:	YUMA

Facility Latitude and Longitude

Latitude (decimal):	32.663333
Longitude (decimal):	-114.570556
Lat/Long Method:	Interpolation - Digital map source (TIGER)
Lat/Long Description:	Center of Facility
Horizontal Accuracy Measure:	10
Horizontal Reference Datum Name:	World Geodetic System of 1984
Source Map Scale Number:	

Owner or Operator

Operator Name:	Monty Lee
Operator Phone:	(928) 344-8100

Mailing Address

Operator Street 1:	121 Spreckels Blvd. building #1
Operator Street 2:	P.O Box 7696 for mailing
Operator City:	Spreckels
Operator State:	CALIFORNIA
Operator ZIP:	93962
Operator ZIP4:	
Operator Foreign State or Province:	
Operator Foreign ZIP:	
Operator Foreign Country:	

Name and title of person or position responsible for Part 68 (RMP) Implementation

RMP Name of Person:	Mike Azzopardi
RMP Title of Person or Position:	President
RMP E-mail Address:	michael@amcool.us

Emergency Contact

Emergency Contact Name:	Mike Azzopardi
Emergency Contact Title:	President
Emergency Contact Phone:	(831) 424-1282
Emergency Contact 24-Hour Phone:	(831) 262-1648
Emergency Contact Ext. or PIN:	
Emergency Contact E-mail Address:	michael@amcool.us

Other Points of Contact

Facility or Parent Company E-mail Address:	bill@amcool.us
Facility Public Contact Phone:	(928) 210-2301
Facility or Parent Company WWW Homepage Address:	

Local Emergency Planning Committee

LEPC:	Yuma County LEPC

Full Time Equivalent Employees

Number of Full Time Employees (FTE) on Site:	30
FTE Claimed as CBI:	

Covered By

OSHA PSM :	Yes
EPCRA 302 :	Yes
CAA Title V:	
Air Operating Permit ID:	

OSHA Ranking

OSHA Star or Merit Ranking:

Last Safety Inspection

Last Safety Inspection (By an External Agency) Date:	15-Jan-2010
Last Safety Inspection Performed By an External Agency:	EPA

Predictive Filing

Did this RMP involve predictive filing?:

Preparer Information

Preparer Name:	Axiom Engineeers
Preparer Phone:	(831) 649-8000
Preparer Street 1:	2511 Garden Road
Preparer Street 2:	
Preparer City:	Monterey
Preparer State:	CALIFORNIA
Preparer ZIP:	93940
Preparer ZIP4:	
Preparer Foreign State:	
Preparer Foreign Country:	
Preparer Foreign ZIP:	

Confidential Business Information (CBI)

CBI Claimed:
Substantiation Provided:
Unsanitized RMP Provided:

Reportable Accidents

Reportable Accidents:	See Section 6. Accident History below to determine if there were any accidents reported for this RMP.

Process Chemicals

Process ID:	1000019047
Description:	Basic Inorganic Chemicals
Process Chemical ID:	1000022651
Program Level:	Program Level 3 process
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Quantity (lbs):	24000
CBI Claimed:	
Flammable/Toxic:	Toxic

Process NAICS

Process ID:	1000019047
Process NAICS ID:	1000019389
Program Level:	Program Level 3 process
NAICS Code:	49312
NAICS Description:	Refrigerated Warehousing and Storage

Section 2. Toxics: Worst Case

Toxic Worst ID: 1000015117

Percent Weight:	
Physical State:	Gas liquified by refrigeration
Model Used:	Areal Locations of Hazardous Atmospheres [ALOHA(R)]
Release Duration (mins):	10
Wind Speed (m/sec):	1.5
Atmospheric Stability Class:	F
Topography:	Rural

Passive Mitigation Considered

Dikes:	
Enclosures:	
Berms:	
Drains:	
Sumps:	
Other Type:	

Section 3. Toxics: Alternative Release

Toxic Alter ID: 1000016645

Percent Weight:	
Physical State:	Gas liquified by refrigeration
Model Used:	Areal Locations of Hazardous Atmospheres [ALOHA(R)]
Wind Speed (m/sec):	7.5
Atmospheric Stability Class:	D
Topography:	Rural

Passive Mitigation Considered

Dikes:	
Enclosures:	
Berms:	
Drains:	
Sumps:	
Other Type:	

Active Mitigation Considered

Sprinkler System:	Yes
Deluge System:	
Water Curtain:	
Neutralization:	
Excess Flow Valve:	
Flares:	
Scrubbers:	
Emergency Shutdown:	Yes
Other Type:	

Section 4. Flammables: Worst Case

No records found.

Section 5. Flammables: Alternative Release

No records found.

Section 6. Accident History

Accident History ID: 1000012098

Date of Accident:	20-Nov-2003
Time Accident Began (HHMM):	1508
NAICS Code of Process Involved:	49312
NAICS Description:	Refrigerated Warehousing and Storage
Release Duration:	000 Hours 05 Minutes

Release Event

Gas Release:	Yes
Liquid Spill/Evaporation:	
Fire:	
Explosion:	
Uncontrolled/Runaway Reaction:	

Release Source

Storage Vessel:	
Piping:	Yes
Process Vessel:	
Transfer Hose:	
Valve:	
Pump:	
Joint:	
Other Release Source:	

Weather Conditions at the Time of Event

Wind Speed:	
Units:	meters/second
Direction:	N
Temperature:	70
Atmospheric Stability Class:	
Precipitation Present:	
Unknown Weather Conditions:	

On-Site Impacts

Employee or Contractor Deaths:	0
Public Responder Deaths:	0
Public Deaths:	0
Employee or Contractor Injuries:	0
Public Responder Injuries:	0
Public Injuries:	0
On-Site Property Damage ($):	0

Known Off-Site Impacts

Deaths:	0
Hospitalization:	0
Other Medical Treatments:	0
Evacuated:	0

Sheltered-in-Place:	0
Off-Site Property Damage ($):	0

Environmental Damage

Fish or Animal Kills:	
Tree, Lawn, Shrub, or Crop Damage:	
Water Contamination:	
Soil Contamination:	
Other Environmental Damage:	

Initiating Event

Initiating Event:	Human Error

Contributing Factors

Equipment Failure:	
Human Error:	Yes
Improper Procedures:	
Overpressurization:	
Upset Condition:	
By-Pass Condition:	
Maintenance Activity/Inactivity:	
Process Design Failure:	
Unsuitable Equipment:	
Unusual Weather Condition:	
Management Error:	
Other Contributing Factor:	

Off-Site Responders Notified

Off-Site Responders Notified:	Notified Only

Changes Introduced as a Result of the Accident

Improved or Upgraded Equipment:	
Revised Maintenance:	
Revised Training:	
Revised Operating Procedures:	
New Process Controls:	
New Mitigation Systems:	
Revised Emergency Response Plan:	
Changed Process:	
Reduced Inventory:	
None:	Yes
Other Changes Introduced:	

Confidential Business Information

CBI Claimed:	

Chemicals in Accident History

Accident Chemical ID:	1000009967
Quantity Released (lbs):	78
Percent Weight:	100.0
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Flammable/Toxic:	Toxic

Section 7. Program Level 3

Description

The SEMCO South Cooling facility uses anhydrous ammonia as a refrigerant in their cold rroms and process cooling operations. Ammonia is the only regulated chemical used at this facility. SEMCO South maintains a release prevention program to eliminate or minimize releases. The program includes regular inspections, monitoring equipment and logging conditions, scheduled maintenance, and operator training. There is a program to analyze releases for ways to prevent a similar future release.

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID:	1000018780
Chemical Name:	Ammonia (anhydrous)
Flammable/Toxic:	Toxic
CAS Number:	7664-41-7
Prevention Program Level 3 ID:	1000015716
NAICS Code:	49312

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):	04-Mar-2010

Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):	15-Jan-2010

The Technique Used

What If:	Yes
Checklist:	
What If/Checklist:	
HAZOP:	
Failure Mode and Effects Analysis:	
Fault Tree Analysis:	
Other Technique Used:	
PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):	12-Jan-2011

Major Hazards Identified

Toxic Release:	Yes
Fire:	Yes
Explosion:	Yes
Runaway Reaction:	
Polymerization:	
Overpressurization:	Yes
Corrosion:	Yes
Overfilling:	Yes
Contamination:	
Equipment Failure:	Yes

Loss of Cooling, Heating, Electricity, Instrument Air:	Yes
Earthquake:	Yes
Floods (Flood Plain):	
Tornado:	
Hurricanes:	
Other Major Hazard Identified:	

Process Controls in Use

Vents:	
Relief Valves:	
Check Valves:	
Scrubbers:	
Flares:	
Manual Shutoffs:	Yes
Automatic Shutoffs:	Yes
Interlocks:	
Alarms and Procedures:	Yes
Keyed Bypass:	
Emergency Air Supply:	
Emergency Power:	
Backup Pump:	
Grounding Equipment:	
Inhibitor Addition:	
Rupture Disks:	
Excess Flow Device:	
Quench System:	
Purge System:	
None:	
Other Process Control in Use:	

Mitigation Systems in Use

Sprinkler System:	Yes
Dikes:	
Fire Walls:	
Blast Walls:	
Deluge System:	
Water Curtain:	
Enclosure:	
Neutralization:	
None:	
Other Mitigation System in Use:	diffuser tank

Monitoring/Detection Systems in Use

Process Area Detectors:	Yes
Perimeter Monitors:	
None:	
Other Monitoring/Detection System in Use:	

Changes Since Last PHA Update

Reduction in Chemical Inventory:	
Increase in Chemical Inventory:	

Change Process Parameters:	
Installation of Process Controls:	
Installation of Process Detection Systems:	
Installation of Perimeter Monitoring Systems:	
Installation of Mitigation Systems:	
None Recommended:	
None:	Yes
Other Changes Since Last PHA or PHA Update:	

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures):	15-Jan-2010

Training

Training Revision Date (The date of the most recent review or revision of training programs):	15-Jun-2010

The Type of Training Provided

Classroom:	Yes
On the Job:	Yes
Other Training:	

The Type of Competency Testing Used

Written Tests:	Yes
Oral Tests:	
Demonstration:	Yes
Observation:	Yes
Other Type of Competency Testing Used:	

Maintenance

Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures):	15-Jan-2010
Equipment Inspection Date (The date of the most recent equipment inspection or test):	15-Jan-2010
Equipment Tested (Equipment most recently inspected or tested):	all

Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):	15-Jan-2010
Change Management Revision Date (The date of the most recent review or revision of management of change procedures):	15-Jan-2010

Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review):	08-Oct-2009

Compliance Audits

Compliance Audit Date (The date of the most recent compliance audit):	15-Jan-2010
Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit):	15-Jan-2011

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)):	
Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation):	

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans):	21-Jul-2010

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures):	21-Jul-2010

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures):	21-Jul-2010
Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance):	21-Jul-2010

Confidential Business Information

CBI Claimed:

Section 8. Program Level 2

Section 9. Emergency Response

Written Emergency Response (ER) Plan

Community Plan (Is facility included in written community emergency response plan?):	Yes
Facility Plan (Does facility have its own written emergency response plan?):	Yes
Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?):	Yes
Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?):	Yes
Healthcare (Does facility's ER plan include information on emergency health care?):	Yes

Emergency Response Review

Review Date (Date of most recent review or update of facility's ER plan):	15-Jan-2010

Emergency Response Training

Training Date (Date of most recent review or update of facility's employees):	15-Jan-2010

Local Agency

Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated):	Yuma County LEPC
Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated):	(928) 373-4861

Subject to

OSHA Regulations at 29 CFR 1910.38:	Yes
OSHA Regulations at 29 CFR 1910.120:	Yes
Clean Water Regulations at 40 CFR 112:	
RCRA Regulations at CFR 264, 265, and 279.52:	
OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254:	
State EPCRA Rules or Laws:	
Other (Specify):	OSHA 29 CFR 1910.119

Executive Summary

The SEMCO South Cooling Facility is located at 3820 E. 36th Street, Yuma, Arizona. The facility handles Anhydrous Ammonia, CAS 7664-41-7, which is listed as Federal Regulated Substance in quantities greater than the Federal Threshold Quantities.
This facility is required to comply with Program 3 requirements since it exceeds the federal threshold level of 10,000lbs. and public receptors are located within the worst-case accidental release toxic end point area. The total quantity of ammonia currently at the site is approximately 24,000 lbs.

RELEASE PREVENTION AND EMERGENCY RESPONSE POLICY

SEMCO South Cooling utilizes inspection procedures to review refrigeration equipment prior to startup and during operations. These procedures identify potential sources of release and equipment corrections required to prevent these releases. Onsite personnel and certified refrigeration contractors review the equipment, as required.
Onsite personnel provide initial emergency response. Onsite personnel will make a preliminary assessment in the event of a release and will provide first response. First response may include emergency equipment shutdown, system isolation, or controlled operation such as pump down to prevent or reduce an off-site release. No emergency operations will be performed that are beyond the capabilities of the operators or other onsite personnel. Local fire and police departments with mutual aide response will provide emergency response for a major release event. The refrigeration contractor would also be on-call to provide emergency response. Emergency response training will be conducted yearly for current employees and as required for new employees. Records will be kept of all training performed at the site for a minimum of five (5) years.

DESCRIPTION OF SOURCE AND SUBSTANCE HANDLED

SEMCO South Cooling utilizes anhydrous ammonia in their precooling and cold storage operations. Fresh produce is brought from the fields and cooled to remove field heat. The produce is then stored in a cold storage warehouse.
All refrigeration equipment is tied together to form a single common system. This equipment consists of portable and permanently installed equipment. The refrigeration system configuration includes three compressor skids, a tower-frame evaporative cooling condenser and high-pressure receiver, a low-pressure receiver with pumps, a Self Contained Automatic Transfer (SCAT) ice machine, an ice maker, one half-car vacuum tube, one full-car vacuum tube, a refrigeration trailer, cold room evaporators, and safety equipment, including a refrigerant discharge diffusion tank.
The system is operated in full configuration during the growing season from November to April. Operations may continue at a reduced level in the off-season.
Anhydrous ammonia (NH3) is a gas in its natural state and is extremely irritating to mucous membranes and lung tissue. The gas is pungent and may be suffocating as shortness of breath and labored breathing can develop if inhaled. Prolonged inhalation of high concentrations may cause bronchitis and/ or pneumonia, with some residual reduction in pulmonary functions. Repeated or prolonged contact of high concentrations of ammonia to the skin can cause frostbite, redness, pain and serious skin burn.

ACCIDENTAL RELEASE PREVENTION PROGRAM

SEMCO South maintains a release prevention program to eliminate or minimize releases. The program includes regular inspections, monitoring equipment and logging conditions, scheduled maintenance, and operator training. There is a program to analyze releases for ways to prevent a similar future release.
The ammonia refrigeration system has specific safety procedures to prevent a release. Operators and mechanics are trained for safe operation and maintenance of the refrigeration system. They are also trained in emergency response procedures in the event of an ammonia release. There are emergency shut off switches for shutting down the system. An alarm and detection system monitors the facility cold rooms for unsafe ammonia concentration levels and for operating conditions outside of safety set points. There is an emergency control box for manual pressure release. Preventive maintenance and safety inspections are used to insure equipment and piping is maintained and operating in a safe manner.

FIVE-YEAR ACCIDENT HISTORY

According to SEMCO South Cooling Personnel, since startup there has been one release of anhydrous ammonia. The quantity of release was below the reportable threshold and no injuries resulted, however it was reported to the appropriate authorities.

EMERGENCY RESPONSE PROGRAM

SEMCO South Cooling is in the process of writing a Business Response Plan. Upon completion, this plan will provide emergency contact personnel information, general emergency response procedures, hazardous material release reporting procedures, chemical inventory information, and emergency evacuation procedures.
In event of a release, certain personnel are designated to determine the potential hazard and coordinate response procedures. The

emergency coordinator is responsible for contacting emergency response agencies, schools, daycare centers, and acute care facilities that may be affected by the release. The coordinator will also be responsible for evacuation of employees if necessary, and for coordination with community emergency responders if off-site evacuations are required.

PLANNED SAFETY IMPROVEMENTS

Additional risk reduction measures may be implemented to further reduce the potential for an accidental release. These measures may include installation of upgraded piping and equipment supports, installation of equipment labeling, and implementation of program aimed specifically at the maintenance, training, and emergency response procedures for the ammonia based refrigeration equipment.